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D4146-1
Job Sheet 183928



Part No: D4146-1

Job Qty: 4 ea

Part Name: Fitting



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/28/18

Job Tracking No:

Due Date: 10/1/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 10-10-05 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	10/1/18	10/1/18	0.00	0.00	Start Up Machining-2		
100	Doosan	4 pcs	10/1/18	10/1/18	0.27	1.60	Doosan		
120	QC	4 pcs	10/1/18	10/1/18	0.00	0.00	QC8		
130	Packaging	4 pcs	10/1/18	10/1/18	0.00	0.00	Packaging3-2		
140	QC21-SA	4 Ea	10/1/18	10/1/18	0.00	0.00	QC21		

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R1.000	303 Round Bar 1.00	6664 ft (1666 ea)	90-Start up Operation	
M303 R1.25		169 ea		

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R1.000	1	35	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fitting	0.290Inches + 0.006 - 0.001	0.296 0.289	Diameter	293
2	Fitting	0.810Inches ± 0.010	0.820 0.800		807
3	Fitting	0.550Inches ± 0.010	0.560 0.540	Diameter	559.5
4	Fitting	0.470Inches ± 0.010	0.480 0.460	Diameter	469
5	Fitting	0.330Inches ± 0.010	0.340 0.320	Diameter	340
6	Fitting	0.063Inches ± 0.010	0.073 0.053		062
7	Fitting	1.790Inches ± 0.030	1.820 1.760		1.7905
8	Fitting	1.700Inches ± 0.030	1.730 1.670		1.706

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

9	Fitting	1.590Inches $\pm$ 0.030	1.620 1.560	1.595
10	Fitting	1.190Inches $\pm$ 0.030	1.220 1.160	1.194
11	Fitting	0.840Inches $\pm$ 0.030	0.870 0.810	.843
12	Fitting	0.810Inches $\pm$ 0.030	0.840 0.780	.811
13	Fitting	0.500Inches $\pm$ 0.030	0.530 0.470	.501
14	Fitting	0.539Inches $\pm$ 0.010	0.549 0.529	Diameter .535

Plex 9/28/18 2:40 PM Dart.lajeunesse.marie

1/4" 18 NPT

9/16 18 UNF-3A

/ UPDATE

Work Order update only

Part: D4146-1
 Job No: 183928
 Serial No/Batch: S122091
 Revision:
 Inspector:
 Exp Date:
 Instructions: Various STC's

Date: 10/29/18

Container No: S122091
 DART AEROSPACE
 1270 Aberdeen Street
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 CANADA
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 Email: sales@dartaero.com
 www.dartaerospace.com

AGAINST DEPARTMENT/PROCESS

Cross tube		Water Jet		Engineering	
Small Fab		Prod. Eng. Coord.		Quality	
Finishing		Rec/Store/Packaging		Other	
Composite		Supplier			

MRB (QSI042) Approval

Disposition

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Root Cause

Environment		No Re-verification	
Design		Operator	
Doc/Data		Offset/Setup	
Equip/Tooling		Supplier	
Handling/Pre		Training	
Material		Use for Testing	
Internal Transport		Poor Information	
Tribal Knowledge		Rushing	
LOA		Product Improvement	
Substation		Process Improvement	
Past Expiry Date		Manufacturing Process	
Misidentified		Past Due	

Pressure/Forced
 Bending
 Centre Not Concentric
 Cracks
 Crimp/Kink/Ripple/Wave
 Cuffs
 Crushing
 Heat Treat
 Wave/Twist in Tube
 Marks/Chatter

Temperature/Cure
 Set-up
 BOM/Route
 Broken/Damage/Defect
 Inspection Incomplete/Unqualified
 Contamination
 Countersink
 Cut Too Short
 Instructions Incomplete/Unclear
 Drill Holes

FAULT CATEGORY

Power Loss/Surge
 Folio/Program
 Grain
 Weld
 Wrong Stock Pulled
 Out of Sequence
 Off-set
 Mislabeled
 Fit/Function
 Misaligned/off center

Positioned Wrong
 Outside Dimensions
 Over/Under tolerance
 Part Incorrect
 Part Lost/Missing
 Part Moved
 Drawing
 Finish
 Misread
 Turning Sequence

OTHER :